

Work Order ID 146203

May 11, 2016 11:54:21 AM

146203

Page 11

Item ID: D3705-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel
 Start Date: 5/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/3/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: SJA Date: 20160517 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3705	E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3705 Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(10) PR/pe 16/06/01

(10) PR/pe 16/06/01

(10) 1
 DAS
 38
 9-89
 JUN 02 2016
 P.T.O.

DQA:

Date: 16-06-23



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>146203</u> Part No. <u>D3705-9</u> NCR No. <u>16-5837</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☒</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☒	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>16-06-02</u>	Step #: <u>100</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval DAS 9-89 JUN 07 2016																																																																	
Description Work Order Deviation 1 hole was offset (outside dimensions outside Dimensions) water jet start cut hole and finish start didn't finish at same place he start		Disposition scrap / destroy no replace		Completed By PR / DC 06/07/2016 Lead hand / Supervisor Approval Verification DAS 38 9-89 JUN 07 2016 QC / QA Coordinator Approval DAS 38 9-89 JUN 07 2016																																																																
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 Item Name: Panel
 Start Date: 5/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/3/2016 Req'd Qty: 10.00 ***10*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				9	1	16/06/07	
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:25 OVEN TEMPERATURE: 320 FINISH TIME: 8:55								

9
38
9.89
JUN 07 2016

9 16-06-09 34 9.89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Page 3

Accept

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

Start Date: 5/20/2016 **Start Qty:** 10.00

Required Date: 6/3/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------------	---------------	------------------	----------------

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

JUN 09 2016

180

Identify as per dwg & Stock Location: Store 0.00

0.00

180

Packaging

Memo

0.00

Packaging

DAS
6
JUN 09 2018

190

QC21- Final Inspection - Work Order Release	0.00
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0.00

190

OC

Memo

0.00

Quality Control

ML5

JUN 10 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

May 11, 2016 11:55:07 AM

Page 1

Work Order ID: 146203

146203

Parent Item: D3705-9

D3705-9

Parent Item Name: Panel

Start Date: 5/20/2016

Required Date: 6/3/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 09-01-09 rev.c as per dwg DD verified by:EC IPP Rev:B
as per dwg RevD DD 10.04.27 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No			sf	456.5830		3.684211			

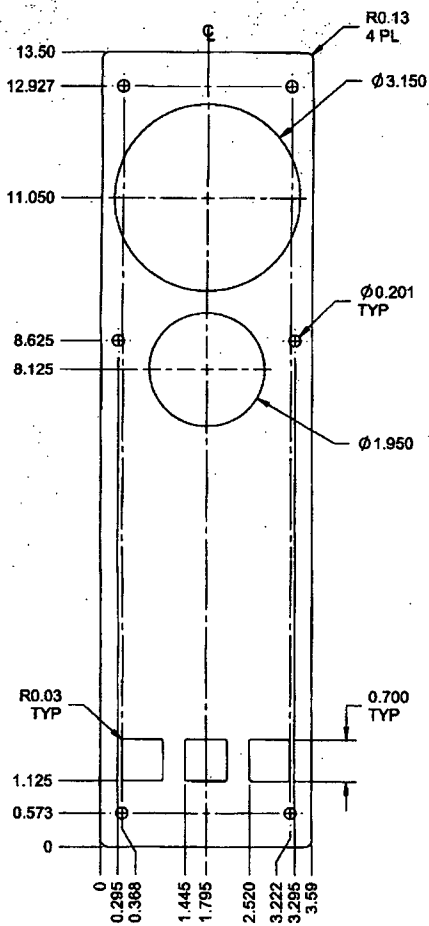
M6061T6S 063

6061-T6 .063 Sheet

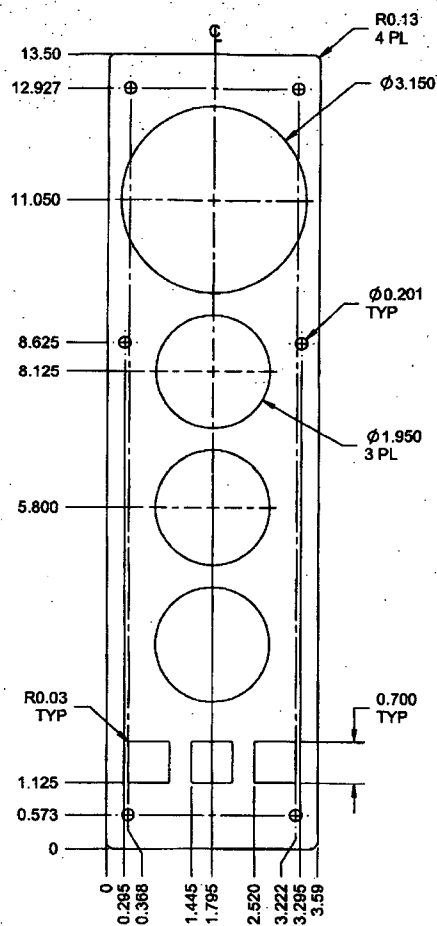
PR/DC 16/06/01

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	120.583	
M132358	44.954	
M133511	24.7	
M134377	50.929	
TPI	336	
M134496	192	
M134604	144	

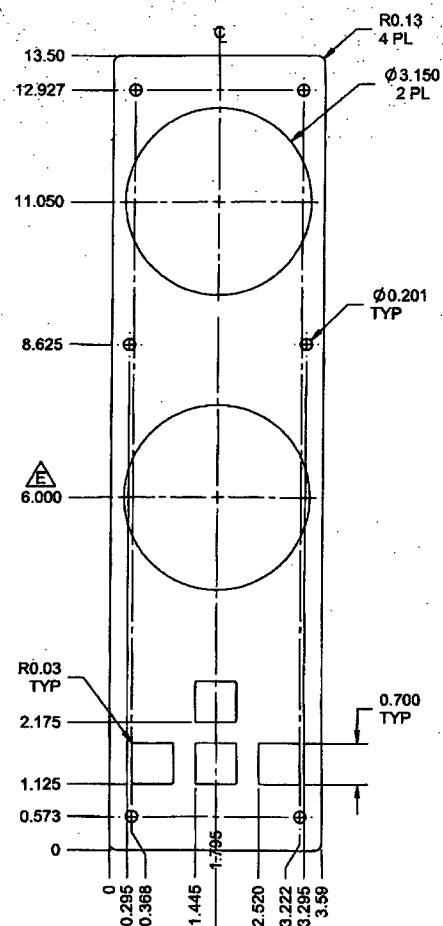
1.6



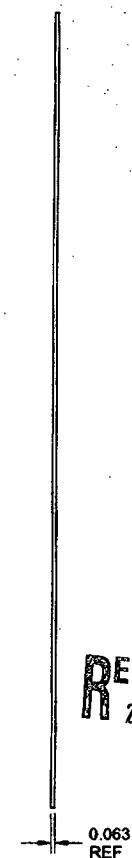
D3705-7 FACE PLATE



D3705-9 FACE PLATE



D3705-11 FACE PLATE



**SIDE VIEW
TYP**

D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M8061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

20160511

24
146203

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 8 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASSY	NTS
DATE	12.11.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGINATED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE
2013-01-16
WMB

FIRST ARTICLE INSPECTION CHECKLIST

DAS

H:\FORMS\Quality Assurance\approved QA\FAI revE